

Work Order ID 71910

Wednesday, July 13, 2011 12:33:14 PM



PRELIMINARY ISSUE

Page 1

Item ID: D4406-043
Revision ID: PRELIM
Item Name: Aft Wearplate Assembly

Accept



Setup Start



Stop



Start Date: 7/13/2011 Start Qty: 1.00
Required Date: 7/15/2011 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: *u*
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4406

PA4

100



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per dwg D4406
prog rev: *PA4*
dwg rev: *PA4*

2-Deburr if required

0.00

0.00

0.00

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

SCRAP

SCRAP

11-7-13

11-7-13

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Page 2

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Start Date: 7/13/2011 Start Qty: 1.00
Required Date: 7/15/2011 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date:
QC: Date:

Tooling: Date:
SPC (Y/N): Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00 - inspected & PAX



QC

Memo

0.00

Quality Control

130

Small Fab
Memo
Form as per dwg D4406

0.00



Small Fab

0.00

Small Fab

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Trizl fit before welding 11.07.18

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Page 3

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Setup Start

Stop

Start Date: 7/13/2011 Start Qty: 1.00

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Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

150

0.00



Large Fab

Memo

0.00

weld wearplate as per dwg D4406

m118/96
m117659

① a/jel 11-07-28

160

0.00



QC

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

Quality Control

11-07-28 ①

170

0.00



Small Fab

Memo

0.00

Apply coating as per dwg D4406

Small Fab

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Page 4

Item ID: D4406-043
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Accept



Setup Start



Stop



Start Date: 7/13/2011 Start Qty: 1.00
Required Date: 7/15/2011 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours
--------------------------------	--------------------------	----------------------

180	QC5- Inspect part completeness to step on W/O	0.00
-----	---	------



QC	Memo	0.00
Quality Control		

190	Identify as per dwg & Stock Location: _____	0.00
-----	---	------



Packaging	Memo	0.00
Packaging		

200	QC21- Final Inspection - Work Order Release	0.00
-----	---	------



QC	Memo	0.00
Quality Control		

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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RD 2385

POSITIVE RECALL

EFFECTIVE 7.13.13 AUTH

RELEASED _____ DATE _____

Picklist Print

Wednesday, July 13, 2011 12:33:11 PM

Work Order ID: 71910

Parent Item: D4406-043

Parent Item Name: Aft Wearplate Assembly







Start Date: 7/13/2011

Required Date: 7/15/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A 11.06.06new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4407-3		Manufactured	No			150	Each	0.0000	1	1			
													
Bar													
M304S18GA		Purchased	No			100	sf	245.6550	3.21	3.378947			
													
304/316 .050 Sheet													

71912 x1

EL 11-7-28

B11-7-13

Location	Loc Qty	Loc Code
MAT020	85.655	
113062	13.655	
116135	3	
116979	69	
MAT021	160	
118217	160	

118217

DART AEROSPACE LTD		Work Order: 71910
Description: APT WEAR PLATE ASSEMBLY		Part Number: D4406-043
Inspection Dwg: D4406-3 Rev: PA4		Page 1 of 1

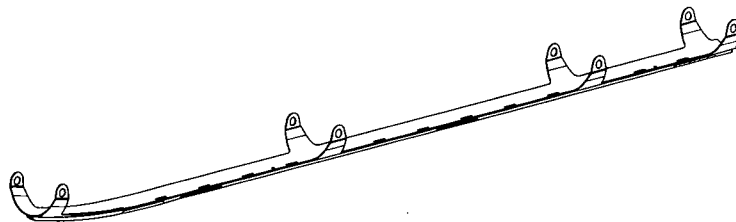
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

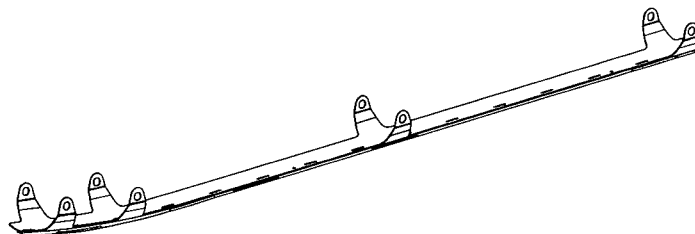
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 188	+005 -001	192	x		V B02	
.561	±.010	.568	2		V	
.30	±.030	.300	2		V	
.88	±.030	.88	2		V	
.13	±.030	.127	2		V	
.31	±.030	.31	2		V	
2.43	±.030	2.442	2		V	
1.76	±.030	1.76	2		V	
7.78	±.030	7.785	2		V	
7.214	±.010	7.216	2		V	
3.63	±.030	3.636	2		V	
7.00	±.030	7.002	2		V	
4.10	±.030	4.100	2		V	
7.78	±.030	7.779	2		V	
7.567	±.010	7.569	2		V	
8.17	±.030	8.163	2		V	
7.00	±.030					
27.50	±.030	27.50	2		T B01	
58.12	±.030	58.12	2		T	
24.995	±.010	24.995	2		T	
47.883	±.010	47.883	2		T	
53.973	±.010	53.973	2		T	
.050	±.010	.048	2		T	
7.144	±.010	7.144	2		V	
Measured by: B	Audited by: S		Prototype Approval:			
Date: 11-7-13	Date: 11/21/14		Date:			

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

to PA4 Day only



D4406-041 FWD WEARPLATE ASSY



D4406-043 AFT WEARPLATE ASSY

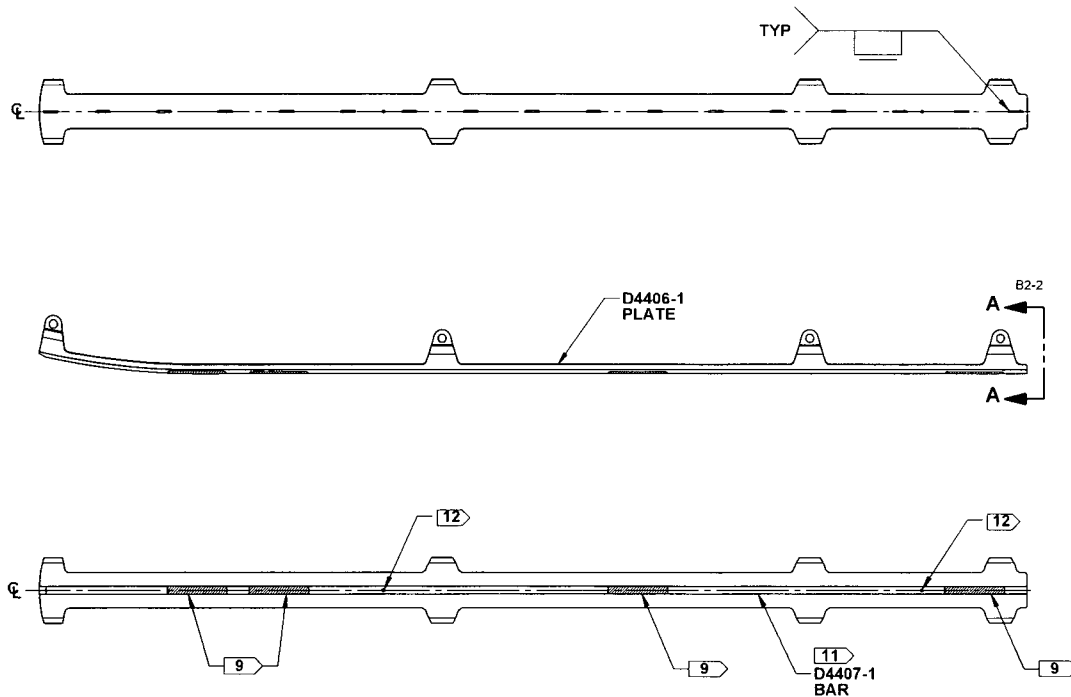
WLO 71910

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D4406-041	FWD WEARPLATE ASSY
2		X	D4406-043	AFT WEARPLATE ASSY
3	1		D4406-1	PLATE
4		1	D4406-3	PLATE
5	1		D4407-1	BAR
6		1	D4407-3	BAR
7	A/R	A/R	2059B	HARDCOAT
8	A/R	A/R	4714	PLUS ONE ROCKGUARD (SEE NOTE 11, SHT 2 & 3)

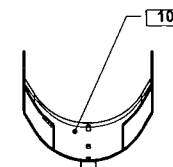
PRELIMINARY ISSUE

11.07.13

PA4	7.77 WAS 7.97 & 7.167 WAS 7.372 (ZN B8-4); 47.883 WAS 47.695 & 53.973 WAS 54.160 (ZN C4-5)		RF	11.07.13
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED		DRAWING NO.	REV. PA4	
MFG. APPR.		D4406	SHEET 1 OF 6	
APPROVED		TITLE	SCALE	
DE APPR.		WEARPLATE ASSY	NTS	
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D4406-041 FWD WEARPLATE ASSY



C3-2 SECTION A-A
SCALE 2X

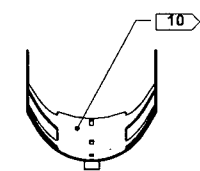
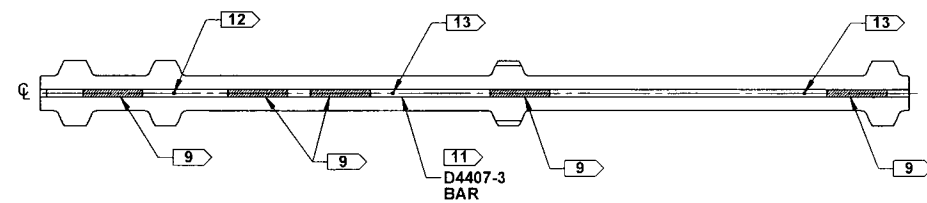
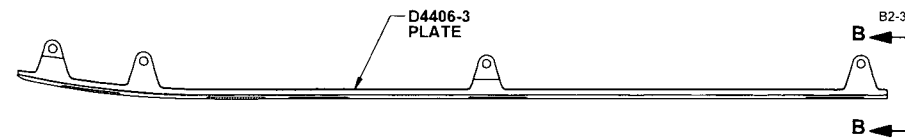
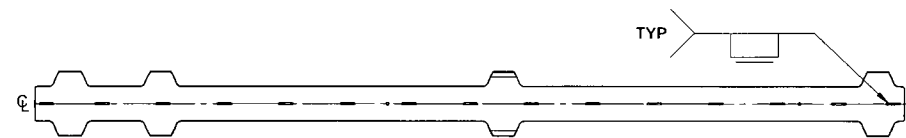
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 5.12 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D4407-1 BAR ON ALL 3 SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) FORM TO MATCH PROFILE OF D4406-1 AT TIME OF WELDING
- 12) TRANSFER $\phi 0.188$ HOLES FROM D4406-1 TO D4407-1

PRELIMINARY ISSUE

RF 11.07.13

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO. D4406	REV. PA4
MFG. APPR.			SHEET 2 OF 6
APPROVED		TITLE WEARPLATE ASSY	SCALE NTS
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DATE	11.07.13		



D4406-043 AFT WEARPLATE ASSY

C3-3 **SECTION B-B**
SCALE 2X

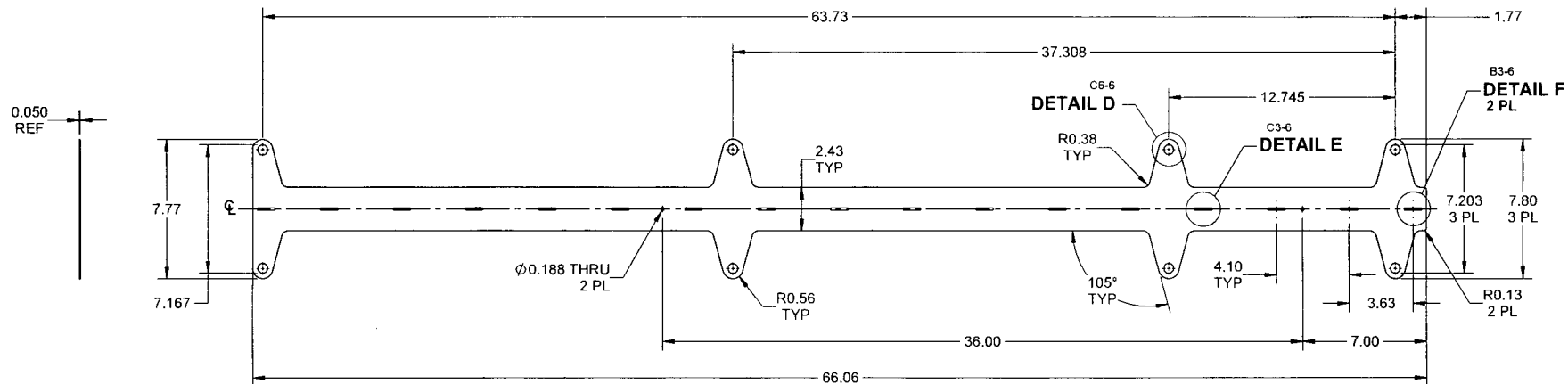
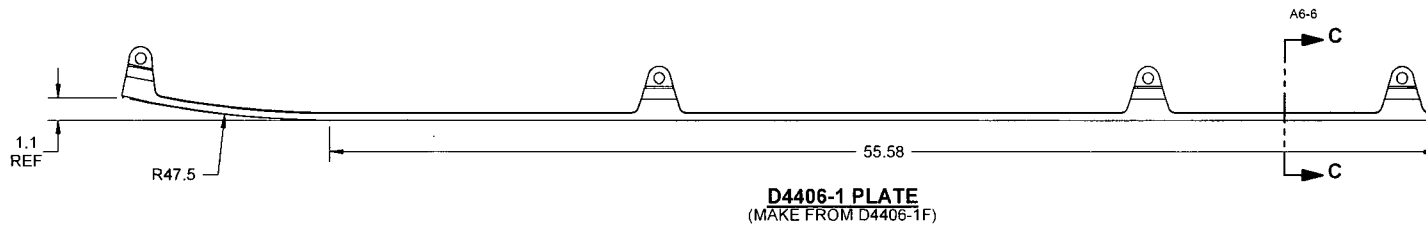
PRELIMINARY ISSUE

11.07.13

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 4.57 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D4407-3 BAR ON ALL 3 SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) FORM TO MATCH PROFILE OF D4406-3 AT TIME OF WELDING
- 12) FILL TOOLING HOLE WITH WELD ONE PLACE ONLY
- 13) TRANSFER $\varnothing 0.188$ HOLES FROM D4406-3 TO D4407-3

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DRAWN	RF		
CHECKED		DRAWING NO. D4406	REV. PA4
MFG. APPR.			SHEET 3 OF 6
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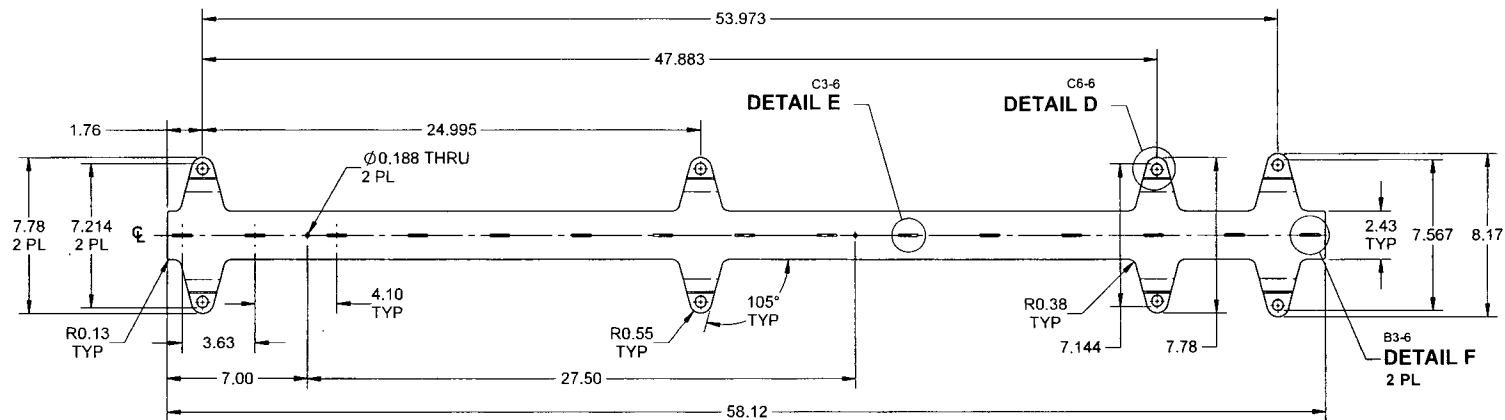
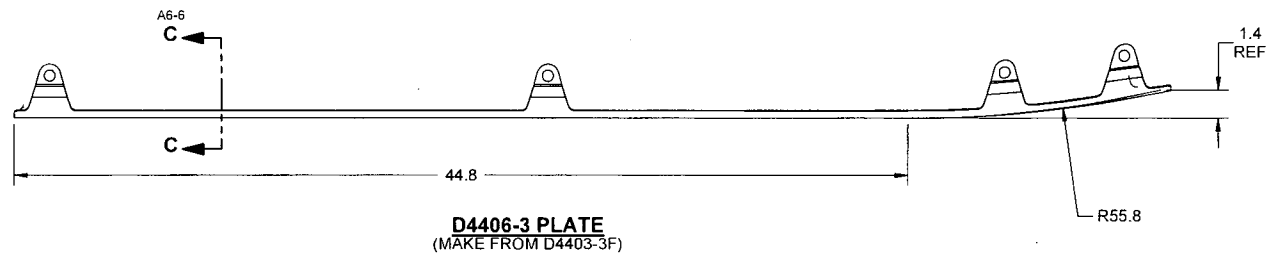


PRELIMINARY ISSUE

11.07.13

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)
PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 2.33 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. PA4
MFG. APPR.		D4406	SHEET 4 OF 6
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D4406-3F FLAT PATTERN

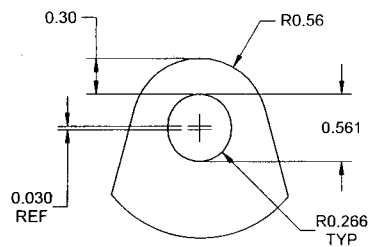
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)
PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.33 lbs

PRELIMINARY ISSUE

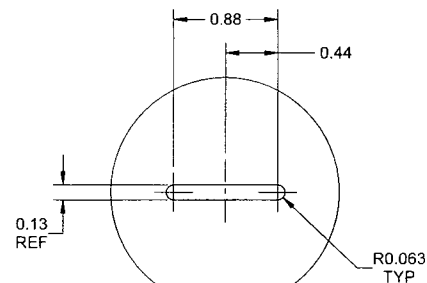
11.07.13

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DRAWN	RF		
CHECKED		DRAWING NO.	REV. PA4
MFG. APPR.		D4406	SHEET 5 OF 6
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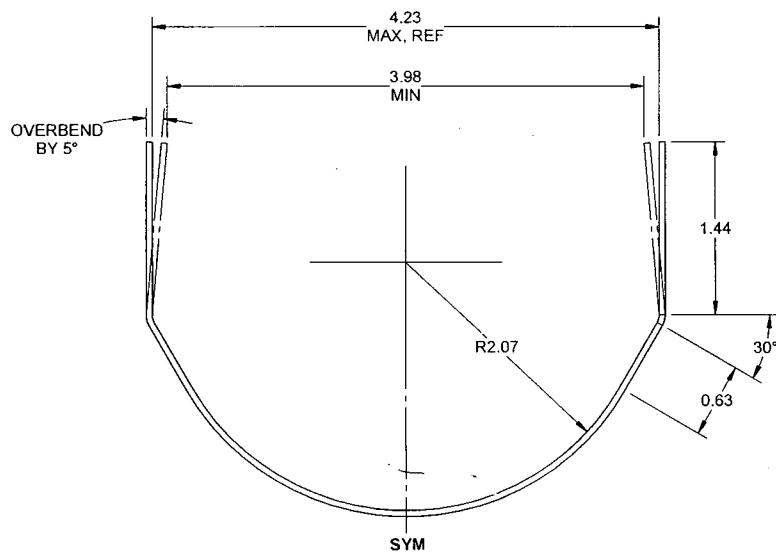
DETAIL D
SLOT DETAIL TYP
SCALE 6X

C3-4
C4-5



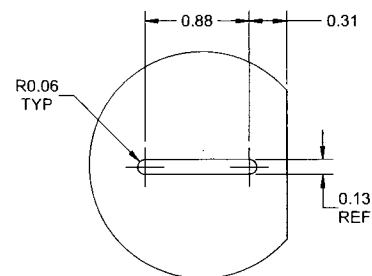
DETAIL E
SLOT DETAIL TYP
SCALE 6X

C2-4
C4-5



DETAIL C
DETAIL TYP
SCALE 6X

D2-4
D8-5



DETAIL F
SLOT DETAIL TYP
SCALE 6X

C1-4
B1-5

PRELIMINARY ISSUE

11.07.13

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA4
MFG. APPR.		D4406	SHEET 6 OF 6
APPROVED		TITLE	SCALE
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Linda Lacelle

From: Roberto Fuentes <rfuentes@dartaero.com>
Sent: July 13, 2011 11:45 AM
To: Linda Lacelle
Cc: David Shepherd; Eric Downing; Eric Charbonneau; Mike Petsche; Dan Stow
Subject: D4406 wearplate update (205 wearplate)

Hi Linda,

I posted PA4 new update D4406 dwg and dxf. I correct D4406-1F/-3F per Dan instructions. Please proceed making another set of -1F/-3F, and this time all holes are in alignment with D2580-045 (green skidtube) proceed in weld D4407-1/-3 bar, and check again with the skidtube.

Thanks,
Roberto